

5084714



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D2962-150
Job Sheet 172880



Part No: D2962-150

Job Qty: 150 ea 157 units

Part Name: 3.540 Outer Tube, Extrud



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/22/18

Job Tracking No: Reference SO 3501

Due Date: 4/11/18

Created By: Michelle Gagnon-Donovan

Type: Stock

Description:

Note: DWG REV B

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup	Run	Workcenter / Supplier	Lead Time	
hrs	Hrs								
90	Start up Operation	150 Ea		4/11/18	0.00	0.00			
100	Purchasing	150 pcs		4/11/18	0.00	0.00	Purchasing		AT 18/06/27
110	Packaging	150 pcs		4/11/18	0.00	0.00	Packaging2		AT 18/06/27
120	QC	150 pcs		4/11/18	0.00	0.00	QC6		D 18-06-27
130	Packaging	150 pcs		4/11/18	0.00	0.00	Packaging3		
140	QC21-SA	150 Ea		4/11/18	0.00	0.00	QC21		

21
9-50 JUN 27 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2962-150P	3.540 Outer Tube, Extrusion	150 pcs (1 ea)	90-Start up Operation	
				150 PCS
				5084713

PIC: 39162
13
9-50

MAR 01 2018

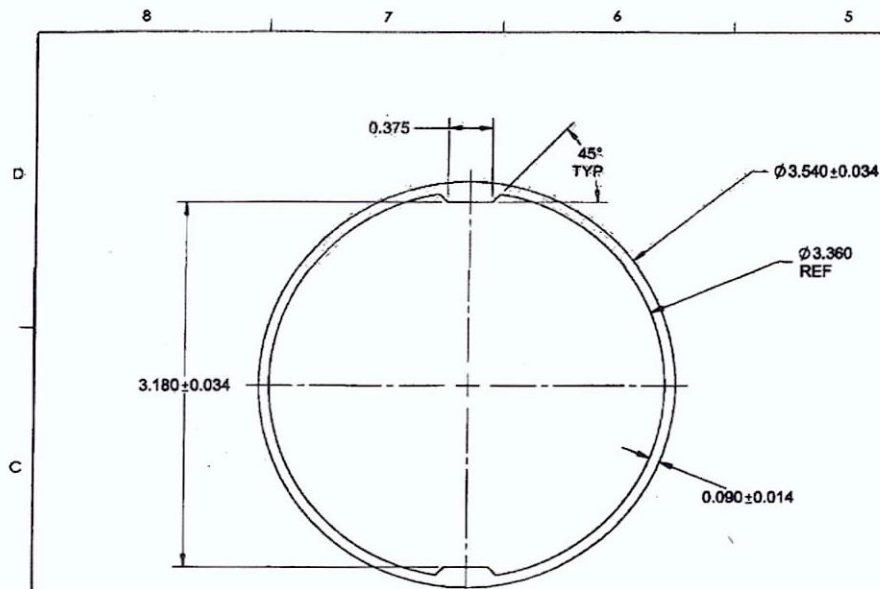
Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2962-150P	150	0	0

Part Specifications

Specifications could not be found.

Plex 3/1/18 2:23 PM dart.lavoie.chantal



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 172880 *md*

FEB 22 2018

RELEASED
2013-06-21

NOTES:

- 1) MATERIAL: 6061-T6/T6510/T6511 ALUMINUM PER AMS-QQ-A-200/8 (OR AMS 4160) OR ASTM B221
MINIMUM YIELD TENSILE STRENGTH = 35 ksi
MINIMUM ULTIMATE TENSILE STRENGTH = 40 ksi
MINIMUM ELONGATION = 8%
A SAMPLE FROM EACH BATCH WILL BE PULL TESTED TO ASTM STANDARD B221 BY AN APPROVED TESTING FACILITY TO ENSURE THAT THE BATCH MEETS THE ABOVE MINIMUM MECHANICAL PROPERTIES.
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.016 TO 0.025 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N AND B/N PER DART QSI 044 6.1
- 7) WEIGHT: 0.105 lb/in
- 8) MANUFACTURED USING BON L CANADA DIE # DAA-3
- 9) NO TOOLING MARKS
- 10) ORDER AS D2962-XXX WHERE XXX = LENGTH IN INCHES
EG. 125 LONG: D2962-125

B	UPDATE FORMAT AND EXTRUSION TOLERANCES	SFM	13.05.09
A	NEW ISSUE	RF	00.03.10
REV.	DESCRIPTION	BY	DATE
DESIGN	CP	DART AEROSPACE USA, INC	
DRAWN	SFM	KENT, WA	
CHECKED	<i>A.P.</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D2962	SHEET 1 OF 1
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	EXTRUSION	NTS
DATE	13.05.09	COPYRIGHT © 2009 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON OR ENTITY WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

PO039162

Supplier: SIG001-VC
Signature Aluminum Canada Inc.
C/O/ T10322C
PO Box 4488, STN A
TORONTO
ON
M5W 4H1 Canada
Phone: 905-427-6550
Fax: 905-427-2246

PO No: PO039162

PO Date: 3/1/18

Due Date: 4/9/18

**Purchase Order
Revision:**

Revision Date:

Ship-To Contact: Lavoie, Chantal
Phone: clavoie@dartaero.com

E-MAILED

MAR 01 2018

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground

Pymt Terms: Net 30

Freight Terms:

Special Comments:

Items										
Line Item	Part	Supplier Part No	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	D2962-150P		3.540 Outer Tube, Extrusion AS PER DWG D2962 REV. B DIE # DAA-3 JOB NO. 172880	Firmed	4/9/18	150 pcs	0 pcs	150 pcs	\$39.43133/pcs	\$5,914.70

Line Item Note EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS
MUST BE WELL PACKAGE, IF NOT IT WILL BE REFUSE

Grand Total: \$5,914.70

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)
A026 certification of material conformance
A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

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DRIVER

**SIGNATURE ALUMINUM CANADA**1850 CLEMENTS RD
PICKERING, ON L1W 3R8**CERTIFICATE OF COMPLIANCE**

Cert Date	Cert No.	Sales Order	Page
06/22/2018	5484975	132340	1
Cust PO	B/L No	Lot	Date
PO039162 R2	038029	901972	06/24/18

Sold To	Ship To
46024 DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7 CANADA	46024 DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7 CANADA

Item No	Part No	Item Description	Cust Part
001	DAA-3-2	150" MILL 6061 T6	D2962150P
Gross Weight	2,449 LBS		
Net Qty	2,321 LBS		157 PCS 6 PKGS
Specification			Die Desc
AMS QQA 200/9 + ASTM B221-08			

Mechanical Tests:

<u>Tensile</u>	<u>Yield</u>			
<u>MPA / KSI</u>	<u>MPA / KSI</u>	<u>% Elongation</u>	<u>Conductivity</u>	<u>HRE</u>
296.6 / 43.0	260.0 / 37.7	9.9	N/A	92

Chemical Analysis:

<u>Si</u>	<u>Fe</u>	<u>Cu</u>	<u>Mn</u>	<u>Mg</u>	<u>Cr</u>	<u>Zn</u>	<u>Ti</u>	<u>V</u>	<u>Zr</u>
0.63	0.27	0.22	0.07	0.98	0.07	0.14	0.01	0.01	0.00

*This Material is Made in Canada**This Material is RoHS Compliant*

This will certify that the material described herein has been inspected and tested in accordance with Signature Aluminum Canada's standard sampling and testing procedures or in accordance with the requirements of any specification forming a part of the material description to the extent indicated herein. Data of chemical composition for the material and test results from samples representative of the material are set forth above hereof or in any attachments hereto. This information shows that the material meets the applicable requirements. Inspection and test records are maintained on file. This certificate shall be deemed apart of and subject to the terms and conditions of warranty set forth on the reverse side of our order acknowledgement form. No other warranties are applicable.

S. Gooder
Quality Manager
Signature Aluminum Canada Inc

ISO 9001/TS16949 Registered Company

Visit us at www.signaturealum.com

Rev A

MATERIAL RECEIPT INSPECTION FORM

MATERIAL: D 2962-150
DATE: 18/06/27

PO / BATCH NO.: P003962 / SO 84714

MATERIAL CERT REC'D: Yes
QUANTITY RECEIVED: 157
QUANTITY INSPECTED: 157
QUANTITY REJECTED: 0

THICKNESS ORDERED: 0.090"
THICKNESS RECEIVED: 0.090"
SHEET SIZE ORDERED: —
SHEET SIZE RECEIVED: —

DESCRIPTION	NCR (Check Y/N)	COMMENTS
SURFACE DAMAGE	Y ☒ N	
CORRECT FINISH	☒ Y N	
CORROSION	Y ☒ N	
CORRECT GRAIN DIRECTION	☒ Y N	
CORRECT MATERIAL PER M-DRAWING	☒ Y N	ASTM B221
CORRECT THICKNESS	☒ Y N	
PHOTO REQUIRED	Y ☒ N	
CORRECT REF # TO LINK CERT	☒ Y N	47:901972
CORRECT MATERIAL IDENTIFICATION	☒ Y N	
CORRECT M# ON THE MATERIAL	☒ Y N	
DOES THIS MATERIAL REQUIRE ENGINEERING SIGN OFF	Y ☒ N	
DOES THIS REQUIRE AN EXTRUSION REPORT	Y ☒ N	

CUT SAMPLE PIECE OF MATERIAL AND PREFORM A HARDNESS CHECK. RECORD RESULTS BELOW					
	HRC	HRB	DUR A	DUR D	WEBSTER
TYPE OF MATERIAL					
SIZE OF TEST SAMPLE					
HARDNESS / DUROMETER READING					

testers located in the Quality Office

QC 18 INSPECTION		ENGINEERING SIGNOFF (if required)	
INSPECTED BY: <u>AR PD.</u>		SIGNED OFF BY: _____	
DATE: <u>18/06/27</u>		DATE: _____	

Attach this inspection sheet with the corresponding material cert and remit to be scanned and received in